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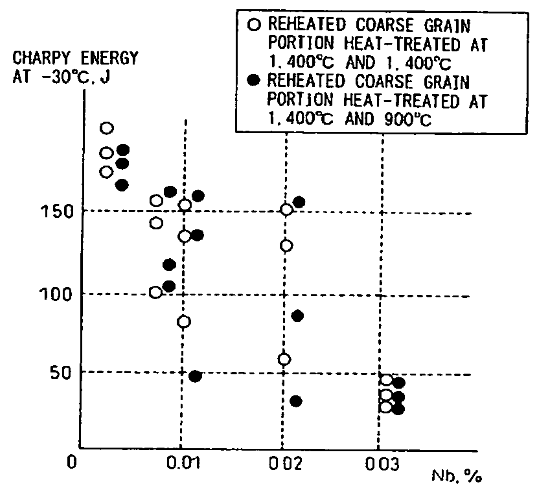
(54) ACIER A HAUTE RESISTANCE AYANT UNE EXCELLENTE TENACITE A BASSE TEMPERATURE ET DANS DES ZONES AYANT ETE CHAUFFEES LORS DE SOUDURE, METHODE POUR LE PRODUIRE ET METHODE POUR PRODUIREDES TUBES EN CET ACIER

(54) HIGH-STRENGTH STEEL EXCELLENT IN LOW TEMPERATURE TOUGHNESS AND TOUGHNESS AT WELD HEAT-AFFECTED ZONE, METHOD FOR PRODUCING THE SAME, AND METHOD FOR PRODUCING HIGH-STRENGTH STEEL PIPE

(57)
The present invention provides an ultra-high-strength steel pipe excellent in weldability on site and a method for producing the steel pipe by improving the reliability of the low temperature toughness of a steel to which elements to enhance hardenability are added for furthering high-strengthening and also improving toughness at a weld heat affected zone subjected to double or more layer welding and, in the method, the steel is made to consist of a structure composed of bainite and/or martensite by containing prescribed amounts of C, Si, Mn, P, S, Ni, Mo, Nb, Ti, Al and N, and, as occasion demands, one or more of B, V, Cu, Cr, Ca, REM and Mg, and regulating C, Si, Mn, Cr, Ni, Cu, V and Mo, those being elements to enhance hardenability, by a specific relational expression. The diameter of prior austenite grains may be regulated in a prescribed range. The method includes the steps of heating a casting to a temperature not lower than the Ac3 point, hot rolling it, and thereafter cooling the resulting hot-rolled steel plate at a prescribed cooling rate.



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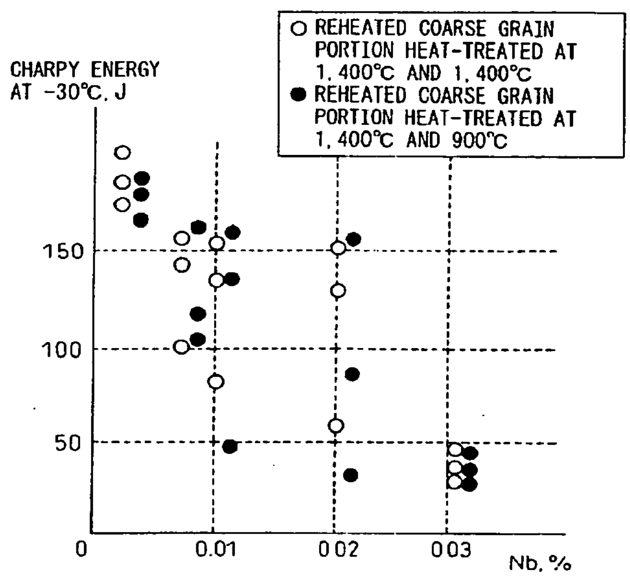
(54) Titre : ACIER A HAUTE RESISTANCE AYANT UNE EXCELLENTE TENACITE A BASSE TEMPERATURE ET DANS DES ZONES AYANT ETE CHAUFFEES LORS DE SOUDURE, METHODE POUR LE PRODUIRE ET METHODE POUR PRODUIRE DES TUBES EN CET ACIER

(54) Title: HIGH-STRENGTH STEEL EXCELLENT IN LOW TEMPERATURE TOUGHNESS AND TOUGHNESS AT WELD HEAT-AFFECTED ZONE, METHOD FOR PRODUCING THE SAME, AND METHOD FOR PRODUCING HIGH-STRENGTH STEEL PIPE



(57) Abrégé/Abstract:
The present invention provides an ultra-high- strength steel pipe excellent in weldability on site and a method for producing the steel pipe by improving the reliability of the low temperature toughness of a steel to which elements to enhance hardenability are added for furthering high-strengthening and also improving toughness at a weld heat affected zone subjected to double or more

(57) Abrégé(suite)/Abstract(continued):
layer welding and, in the method, the steel is made to consist of a structure composed of bainite and/or martensite by containing prescribed amounts of C, Si, Mn, P, S, Ni, Mo, Nb, Ti, Al and N, and, as occasion demands, one or more of B, V, Cu, Cr, Ca, REM and Mg, and regulating C, Si, Mn, Cr, Ni, Cu, V and Mo, those being elements to enhance hardenability, by a specific relational expression. The diameter of prior austenite grains may be regulated in a prescribed range. The method includes the steps of heating a casting to a temperature not lower than the Ac_3 point, hot rolling it, and thereafter cooling the resulting hot-rolled steel plate at a prescribed cooling rate.

HIGH-STRENGTH STEEL EXCELLENT IN LOW TEMPERATURE TOUGHNESS AND TOUGHNESS AT WELD HEAT-AFFECTED ZONE, METHOD FOR PRODUCING THE SAME, AND METHOD FOR PRODUCING HIGH-STRENGTH STEEL PIPE

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to methods for producing a ultra-high-strength hot-rolled steel having a tensile strength of not lower than 800 MPa, in particular not lower than 900 MPa, and being excellent in toughness of a base steel and toughness at a weld heat-affected zone in the temperature range from -60°C to 0°C (hereunder referred to as "low temperature toughness" and "weld heat-affected zone toughness"), and for producing a steel plate and a steel pipe made of the hot-rolled steel.

Such ultra-high-strength hot-rolled steels are, after being further processed and welded, widely used for line pipes for the transport of natural gas or crude oil, pressure vessels, welded structures and the like.

2. Description of the Related Art

In recent years, a steel plate for a line pipe, for water pumping (for a penstock for example), or for a pressure vessel is required to have improved high strength and low temperature toughness. For example, in the case of a steel plate for a line pipe, various studies have already been undertaken with regard to the production of a ultra-high-strength steel plate having a tensile strength of not lower than 800 MPa (not lower than X100 in the API standard) and high-strength steels excellent in low temperature toughness, weld heat-affected zone toughness and weldability are disclosed in Japanese Patent Nos. 3244986 and 3262972. In addition, a ultra-high-strength line pipe having a tensile strength of not lower than 900 MPa and the production method

thereof are disclosed in Japanese Unexamined Patent Publication No. 2000-199036.

However, in a steel plate for a line pipe disclosed in the above-mentioned Japanese Patent Nos. 3244986 and 3262972, though the Charpy absorbed energy at -20°C at a heat-affected zone to which single layer welding is applied is not lower than 100 J and thus very good, weld heat-affected zone toughness sometimes deteriorates at a heat-affected zone to which double or more layer welding is applied under some welding conditions.

Further, in a steel plate for a line pipe disclosed in the above-mentioned Japanese Patent Nos. 3244986 and 3262972 and also in a ultra-high-strength line pipe disclosed in the above-mentioned Japanese Unexamined Patent Publication No. 2000-199036, though the Charpy absorbed energy of a base steel at -40°C is not lower than 200 J on the average when the number of the specimens (hereunder referred to as "n") subjected to the test by using the same material and under the same test conditions is three and the result is very good, the problem here is that the Charpy absorbed energy of some specimens is lower than 200 J and is dispersed widely in some cases.

As a result of studying the problem of the dispersion of low temperature toughness in detail, it was clarified that Charpy absorbed energy was lower than about 200 J with a probability of about 20 percent when Charpy impact test was performed at -40°C under an increased number n, and further that Charpy absorbed energy of some specimens was not higher than 100 J and brittle fractured faces were observed on the fractured surfaces of the specimens when the Charpy impact test was performed in the temperature range from -60°C to not higher than -40°C.

Meanwhile, the present inventors proposed a method for improving low temperature toughness by

contriving a welding method described in Japanese Patent Application No. 2001-336670. However, it was also clarified that the proposed method was not immediately applicable because it was not suitable for mass production and required the introduction of new equipment. In view of the above situation, the development of a high-strength line pipe excellent in low temperature toughness at both a base steel and a weld is required.

SUMMARY OF THE INVENTION

The present invention provides a ultra-high-strength steel having a tensile strength of not lower than 800 MPa and a steel pipe made thereof, the steel being excellent in weld heat-affected zone toughness, particularly in shelf energy at a weld heat-affected zone when multi-layer welding is applied; having a Charpy absorbed energy of a base steel at -40°C being not lower than 200 J on the average and with little dispersion; having excellent low temperature toughness; and further being easily weldable at a site. Here, shelf energy is Charpy absorbed energy measured in the temperature range where a material ductilely fractures at one hundred percent when a Charpy impact test is applied at various temperatures to the material that brittlely fractures at a low temperature.

The present inventors carried out intensive studies on the chemical components of a steel material and the microstructure thereof for obtaining a high-strength steel having a tensile strength of not lower than 800 MPa (not lower than X100 in the API standard); having shelf energy of not lower than 100J at a weld heat-affected zone to which multi-layer welding is applied; having Charpy absorbed energy of a base steel not lower than 200 J on the average and with little dispersion in the temperature range of not higher than -40°C; and further being easily weldable on site.

As a result of the studies, firstly, the present

inventors made it clear that the deterioration of low temperature toughness in double layer welding was caused by Nb carbonitride and then confirmed that the reduction of an Nb amount was extremely effective in avoiding the deterioration. Secondly, with regard to a base steel, low Charpy absorbed energy was observed sometimes under some test conditions, and the present inventors made it clear that the low Charpy absorbed energy was caused by coarse grains which are partially existing, and found that the reduction of an Nb amount was extremely effective as a countermeasure.

The present invention of a high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness was accomplished by further controlling a P value that was an index of hardenability in an appropriate range for enhancing strength that was lowered once by the decrease in an Nb amount.

The present invention was established on the basis of the above findings and the gist thereof is as follows:

(1) A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness, characterized by: containing, in mass,

C: 0.02 to 0.10%,
Si: not more than 0.6%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.003%,
Ni: 0.01 to 2.0%,
Mo: 0.2 to 0.6%,
Nb: less than 0.010%,
Ti: not more than 0.030%,
Al: not more than 0.070%, and
N: not more than 0.0060%,

with the balance consisting of Fe and unavoidable impurities; the P value of the steel defined by the following expression being in the range from 1.9 to 3.5; and the microstructure of the steel being mainly composed

of martensite and bainite:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5.$$

(2) A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness, characterized by: containing, in mass,

C: 0.02 to 0.10%,
Si: not more than 0.6%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.003%,
Ni: 0.01 to 2.0%,
Mo: 0.1 to 0.6%,
Nb: less than 0.010%,
Ti: not more than 0.030%,
B: 0.0003 to 0.0030%,
Al: not more than 0.070%, and
N: not more than 0.0060%, so as to satisfy the expression $Ti - 3.4N \geq 0$,

with the balance consisting of Fe and unavoidable impurities; the P value of the steel defined by the following expression being in the range from 2.5 to 4.0; and the microstructure of the steel being composed of martensite and bainite:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo.$$

(3) A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness according to the item (1) or (2), characterized by further containing, in mass, one or more of

V: 0.001 to 0.10%,
Cu: 0.01 to 1.0%,
Cr: 0.01 to 1.0%,
Ca: 0.0001 to 0.01%,
REM: 0.0001 to 0.02%, and
Mg: 0.0001 to 0.006%.

(4) A high-strength steel excellent in low

temperature toughness and weld heat-affected zone toughness according to any one of the items (1) to (3), characterized by the average diameter of the prior austenite grains in the steel being not larger than 10 μm.

(5) A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness, characterized by: containing, in mass,

C: 0.02 to less than 0.05%,
Si: not more than 0.6%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.001%,
Ni: 0.01 to 2.0%,
Mo: 0.1 to 0.6%,
Nb: less than 0.010%,
Ti: not more than 0.030%,
B: 0.0003 to 0.0030%,
Al: not more than 0.070%, and
N: not more than 0.0060%, so as to satisfy the expression $Ti - 3.4N \geqq 0$, and further one or more of

V: 0.001 to 0.10%,
Cu: 0.01 to 1.0%, and
Cr: 0.01 to 1.0%,

with the balance consisting of Fe and unavoidable impurities; the P value of the steel defined by the following expression being in the range from 2.5 to 4.0; the microstructure of the steel being composed of martensite and bainite; and the average diameter of the prior austenite grains in the steel being not larger than 10 μm:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo.$$

(6) A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness, characterized by: containing, in mass,

C: 0.02 to less than 0.05%,
Si: not more than 0.6%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.001%,
Ni: 0.01 to 2.0%,
Mo: 0.1 to 0.6%,
Nb: less than 0.010%,
Ti: not more than 0.030%,
B: 0.0003 to 0.0030%,
Al: not more than 0.070%, and
N: not more than 0.0060%, so as to satisfy the expression Ti - 3.4N ≧ 0, and further one or more of
V: 0.001 to 0.10%,
Cu: 0.01 to 1.0%,
Cr: 0.01 to 1.0%, and
Ca: 0.0001 to 0.01%,

with the balance consisting of Fe and unavoidable impurities; the P value of the steel defined by the following expression being in the range from 2.5 to 4.0; the microstructure of the steel being composed of martensite and bainite; and the average diameter of the prior austenite grains in the steel being not larger than 10 μm:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo.$$

(7) A method for producing a high-strength steel plate excellent in low temperature toughness and weld heat-affected zone toughness, the method being the one for producing a steel plate from a casting containing components according to any one of the items (1) to (3), (5) and (6), characterized by: reheating the casting to a temperature of not lower than the Ac_3 point; hot rolling it; and thereafter cooling the resulting steel sheet at a cooling rate not lower than 1°C/sec. to a temperature not higher than 550°C.

(8) A method for producing a high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to the item (7), characterized by: cold-forming a cooled steel plate into a pipe; and thereafter applying seam welding to the abutted portion thereof.

(9) A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by, in the pipe having a seam-welded portion: the base steel containing, in mass,

C: 0.02 to 0.1%,
Si: not more than 0.8%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.003%,
Ni: 0.01 to 2%,
Mo: 0.2 to 0.8%,
Nb: less than 0.010%,
Ti: not more than 0.03%,
Al: not more than 0.1%, and
N: not more than 0.008%,

with the balance consisting of Fe and unavoidable impurities; the P value defined by the following expression being in the range from 1.9 to 4.0; and the microstructure being mainly composed of martensite and bainite:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5.$$

(10) A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by, in the pipe having a seam-welded portion: the base steel containing, in mass,

C: 0.02 to 0.10%,
Si: not more than 0.8%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.003%,

Ni: 0.01 to 2%,
Mo: 0.1 to 0.8%,
Nb: less than 0.010%,
Ti: not more than 0.030%,
B: 0.0003 to 0.003%,
Al: not more than 0.1%, and
N: not more than 0.008%, so as to satisfy the expression $Ti - 3.4N \geqq 0$,

with the balance consisting of Fe and unavoidable impurities; the P value defined by the following expression being in the range from 2.5 to 4.0; and the microstructure being mainly composed of martensite and bainite:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo.$$

(11) A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to the item (9) or (10), characterized by further containing, in mass, one or more of

V: 0.001 to 0.3%,
Cu: 0.01 to 1%,
Cr: 0.01 to 1%,
Ca: 0.0001 to 0.01%,
REM: 0.0001 to 0.02%, and
Mg: 0.0001 to 0.006%.

(12) A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to any one of the items (9) to (11), characterized by the average diameter of the austenite grains in the steel pipe being not larger than 10 μm.

(13) A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by, in the pipe having a seam-welded portion: the base steel containing, in mass,

C: 0.02 to less than 0.05%,

Si: not more than 0.8%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.001%,
Ni: 0.01 to 2%,
Mo: 0.1 to 0.8%,
Nb: less than 0.010%,
Ti: not more than 0.030%,
B: 0.0003 to 0.003%,
Al: not more than 0.1%, and
N: not more than 0.008%, so as to satisfy the expression Ti - 3.4N ≧ 0, and further one or more of
V: 0.001 to 0.3%,
Cu: 0.01 to 1%, and
Cr: 0.01 to 1%,

with the balance consisting of Fe and unavoidable impurities; the P value defined by the following expression being in the range from 2.5 to 4.0; the microstructure being mainly composed of martensite and bainite; and the average diameter of the austenite grains being not larger than 10 μm:

$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo$.

(14) A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by, in the pipe having a seam-welded portion: the base steel containing, in mass,
C: 0.02 to less than 0.05%,
Si: not more than 0.8%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.003%,
Ni: 0.01 to 2%,
Mo: 0.1 to 0.8%,
Nb: less than 0.010%,
Ti: not more than 0.030%,

B: 0.0003 to 0.003%,

Al: not more than 0.1%, and

N: not more than 0.008%, so as to satisfy the expression Ti - 3.4N ≧ 0, and further one or more of

V: 0.001 to 0.3%,

Cu: 0.01 to 1%,

Cr: 0.01 to 1%, and

Ca: 0.0001 to 0.01%,

with the balance consisting of Fe and unavoidable impurities; the P value defined by the following expression being in the range from 2.5 to 4.0; the microstructure being mainly composed of martensite and bainite; and the average diameter of the austenite grains being not larger than 10 μm:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo.$$

(15) A method for producing a high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by: reheating the casting containing components according to any one of the items (9) to (14) to a temperature of not lower than the Ac_3 point; hot rolling it; thereafter cooling the resulting steel sheet at a cooling rate not lower than 1°C/sec. to a temperature not higher than 550°C; cold-forming the cooled steel sheet into a tubular shape; then applying submerged arc welding to the abutted portion from the outer and inner sides thereof; and thereafter subjecting the steel pipe to pipe expansion.

(16) A method for producing a high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to item (15), characterized by heating the seam-welded portion of the steel pipe to 300°C to 500°C before pipe expansion.

(17) A method for producing a high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to item (15),

characterized by heating the seam-welded portion of the steel pipe to 300°C to 500°C after pipe expansion.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a graph showing the influence of Nb amounts on toughness at reheated coarse grain portions.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

Firstly, weld heat-affected zone toughness is explained hereunder. Two-pass welding was applied to various kinds of ultra-high-strength steels and then the toughness at welds and weld heat-affected zones at -20°C was evaluated by applying a Charpy impact test to specimens each of which had a notch at an intersection of outer and inner welds or at a portion 1 mm away from an intersection of the outer and inner welds. A mating portion means a point where the beads of double-layer weld intersect with each other on the cross section perpendicular to a welding direction. As a result of the evaluation, almost one hundred percent of all fractured surfaces were brittle fractured faces and, in some cases, the Charpy absorbed energy was low at not higher than 50 J.

As a result of investigating the fractured surfaces precisely, it was made clear that the brittle fracture originated from the following portions: (1) the region from a mating portion to a portion 1 mm away therefrom in a weld heat-affected zone that was heated once to a temperature immediately below the melting point and then reheated to a temperature immediately above the Ac_3 point, (2) the region that was reheated to a temperature immediately below the melting point, and (3) the region that was heated once to a temperature immediately below the melting point. The probability of the occurrence of brittle fracture at the respective regions was about 60% in (1), about 30% in (2), and about 10% in (3).

The result means that toughness at a reheated portion, where grains are coarsened by the influence of the one time heating, must be improved. Then, the

present inventors, as a result of observing the fractured surfaces further precisely, confirmed that Nb combined carbonitride existed at the initiation point of the brittle fracture and found the possibility of improving toughness at a weld heat-affected zone, particularly at a reheated coarse grain portion that was influenced twice heat affects, by decreasing an Nb amount.

On the basis of the above findings, the present inventors investigated the influence of Nb on weld heat-affected zone toughness by simulating the influence of heat caused by double layer welding through weld reproducing heat cycle test. Steel plates were produced by controlling the addition amounts of the elements other than Nb in the range specified in claim 1 or 2 and varying the Nb amount in the range from 0.001 to 0.04 in terms of mass percent and test pieces were prepared. The heat cycle conditions corresponding to 2.5 kJ/mm in terms of heat input were adopted. That is, the first heat treatment was applied to the test pieces under the conditions that a test piece was heated at a heating rate of 100°C/sec. to a temperature of 1,400°C, retained at the temperature for one second, and thereafter cooled at a cooling rate of 15°C/sec. in the temperature range from 500°C to 800°C, and, in addition to that, the second heat treatment was applied thereto under the conditions that the heating temperature was set at 1,400°C or 900°C with the conditions of heating rate, retention time, cooling temperature and cooling rate being identical to the first heat treatment. Further, test pieces of a standard dimension for V-notch Charpy impact tests were prepared in conformity with JIS Z 2202 and the Charpy impact tests were performed at -40°C in conformity with JIS Z 2242.

The results are shown in Figure 1. It was clarified that, in the steels to which Nb was added to not less than 0.01%, the Charpy absorbed energy was sometimes not higher than 50 J, but, in the steels to which Nb was added to less than 0.01%, Charpy absorbed energy of not

higher than 50 J disappeared and the toughness at a reheated coarse grain portion remarkably improved. When the fractured surface of a test piece of a Nb added steel whose Charpy absorbed energy was not higher than 50 J was observed, almost the entire surface was a brittle fractured face and Nb combined carbonitride existed at the initiation point of the brittle fractured face. On the other hand, when the fractured surface of a steel having an Nb content of less than 0.01% after subjected to Charpy impact test was observed, no Nb combined carbonitride existed at the initiation point of the brittlely fractured face. Consequently, the present inventors succeeded in improving toughness at the above-mentioned brittle regions by reducing an Nb amount to less than 0.01%.

Next, the low temperature toughness of a base steel is explained hereunder. It is necessary to make a structure mainly composed of bainite and martensite transformed from particulate unrecrystallized austenite for securing an excellent low temperature toughness in a ultra-high-strength steel pipe having a tensile strength of not lower than 800 MPa, particularly not lower than 900 MPa. When coarse grains are mixed or the fraction of bainite and martensite is not sufficiently high, low Charpy absorbed energy is obtained, the Charpy absorbed energy representing the property of stopping a high-speed ductile fracture. The present inventors applied Charpy impact tests to base steels at -60°C and precisely investigated the structures in the vicinity of fractured portions of the test pieces that could not achieve the Charpy absorbed energy of not lower than 200 J. As a result of the investigation, it was found that coarse grains 10 to 100 μm in diameter existed in a structure and they caused the reduction of Charpy absorbed energy.

The cast structure of a continuously cast casting containing relatively small amount of alloying elements and having a tensile strength of not higher than 800 MPa

is generally composed of a composite structure of ferrite and bainite or of ferrite and pearlite. When the casting is reheated for hot rolling, new austenite is generated abundantly mainly from ferrite grain boundaries and, when the heating temperature is around 950°C, that is, immediately above the Ac_3 point, the composite structure transforms into grain adjusted austenite about 20 μm in average grain diameter. When a steel plate is produced through succeeding hot rolling, the structure has a finer grain due to recrystallization and becomes an almost uniform grain adjusted structure having austenite grains about 5 μm in average diameter. However, it is estimated that, when a steel to which elements to enhance hardenability are added for further strengthening, like a high-strength steel having a tensile strength of not lower than 800 MPa, is hot rolled, coarse grains partially remain and low temperature toughness deteriorates.

In view of this situation, the present inventors investigated the influence of components on a structure in detail and found that, when an Nb amount was reduced to less than 0.01%, grains after hot rolling became fine and coarse grains partially existing disappeared. The effect of the reduction of an Nb amount can be explained as follows.

To begin with, the cause of the fact that coarse grains partially remain when an Nb amount is large is explained. A ultra-high-strength steel having a tensile strength of not lower than 800 MPa, particularly not lower than 900 MPa, generally contains relatively abundantly alloying elements, such as Mn, Ni, Cu, Cr and Mo, that provide a high hardenability. When such a steel is produced through continuous casting or the like, the structure of a casting after it is cooled to the room temperature is made to consist of a single phase of coarse bainite (hereunder referred to as "bainite"), the

crystal grain diameter of which is not smaller than 1 mm in terms of prior austenite grain diameter, a single phase of martensite (hereunder referred to as "martensite"), or a structure mainly composed of bainite and martensite (hereunder referred to as "bainite and martensite dominant structure"). Such a structure contains fine retained austenite in its grains. Note that, though the structures of both bainite and martensite are lath structures and they can hardly be identified with an optical microscope, they can be identified by hardness measurement.

When a casting having such a cast structure as described above is heated to a temperature in the range from 900°C to 1,000°C, the reaction of generating new austenite grains by the transformation from prior austenite grain boundaries (hereunder referred to as "normal ferrite/austenite transformation") and the reaction of generating coarse austenite grains not smaller than 1 mm in size by the easy growth and consolidation of the aforementioned retained austenite (hereunder referred to as "abnormal ferrite/austenite transformation") are generated.

When Nb is further added to such a steel, fine Nb carbide forms and therefore the growth of grains during heating is suppressed. Therefore, when a steel is heated in the temperature range from a temperature immediately above the Ac_3 point to 1,100°C for example, the growth of austenite grains generated by ordinary austenite transformation, namely secondary recrystallization, is suppressed. As a result, austenite grains not smaller than 1 mm in size, almost the same size as prior austenite grains in a casting, are generated partially by abnormal ferrite/austenite transformation. If such coarse austenite grains are generated in a steel during heating, as recrystallization after hot rolling hardly occurs, the austenite grains remain partially as grains not smaller than 50 μm in size and those coarse grains

cause the deterioration of low temperature toughness.

When a steel is heated in the temperature range of not lower than 1,150°C, Nb combined carbide that acts as pinning grains dissolves and the growth of grains generated by ordinary austenite transformation from prior austenite grain boundaries, namely secondary recrystallization, is accelerated, and, by so doing, the size of austenite grains is properly adjusted. When a casting having such a structure is hot rolled, though the average grain diameter increases to some extent, coarse grains about 50 μm in size are not observed at all. However, coarse grains smaller than about 20 μm in size still remain.

In contrast with the above, since a casting of a steel wherein an Nb amount is reduced to less than 0.01% has little Nb carbide, the effect of suppressing secondary recrystallization is weak. Therefore, when the casting is heated in the temperature range from 950°C to 1,100°C, secondary recrystallization is accelerated and, by so doing, the grains generated by normal austenite transformation erode coarse grains generated by abnormal ferrite/austenite transformation and the structure becomes uniform. When a casting having such a structure is hot rolled, a uniform structure having grains about 10 μm in average diameter is obtained and coarse grains of not smaller than 20 μm do not remain any more. Note that, as the coarsening of austenite grains after secondary recrystallization is suppressed as the heating temperature lowers, grains after hot rolling become fine.

As explained above, the present inventors found that, even in a casting to which alloying elements with a high hardenability were added relatively abundantly for high-strengthening and which had a single phase of bainite, a single phase of martensite, or a bainite and martensite dominant structure, those being apt to generate coarse austenite grains partially by abnormal

ferrite/austenite transformation during heating, it was possible to conspicuously suppress the generation of coarse grains by reducing an Nb amount to less than 0.01%. On the basis of the finding, the present inventors succeeded in the development of a high-strength steel as a base steel having excellent low temperature toughness of not lower than 200 J in terms of Charpy absorbed energy when the base steel was subjected to a Charpy impact test in the temperature range from -60°C to lower than -40°C.

However, it is thought that, when an Nb amount is reduced, the recrystallization temperature lowers and unrecrystallization rolling is not sufficiently performed. The present inventors investigated the behavior of austenite recrystallization in a steel to which 0.005% Nb was added and a steel to which 0.012% Nb was added, both the steels containing, in mass, 0.05% C, 0.25% Si, 2% Mn, 0.01% P, 0.001% S, 0.5% Ni, 0.1% Mo, 0.015% Ti, 0.0010% B, 0.015% Al, 0.0025% N, 0.5% Cu and 0.5% Cr. As a result of the investigation, it was clarified that the recrystallization temperature of either of the steels was in the temperature range from 900°C to 950°C regardless of the addition amount of Nb, and, in a steel to which Mn, Ni, Cu, Cr and Mo were added abundantly, the recrystallization temperature did not change regardless of the addition of Nb. Therefore, it was proved that it was not essential to add Nb from the viewpoint of the recrystallization of austenite.

Further, as the reduction of an Nb amount causes the decrease of strength, the present inventors studied the addition amount of elements to enhance hardenability and contrived to secure both strength and low temperature toughness simultaneously by controlling a P value, that was an index of hardenability, in an appropriate range. As a result of investigating, in detail, the influence of alloying elements on hardenability of a steel wherein an addition amount of Nb was reduced to less than 0.01%, it

was clarified that, in the case of a steel not containing B, by defining the P value to P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5, hardenability was evaluated properly and the appropriate range of the P value was from 1.9 to 3.5. On the other hand, it was clarified that, in the case of a steel to which B is added, the P value was defined by P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo and the appropriate range of the P value was from 2.5 to 4.0. By controlling a P value to an appropriate range, the present inventors succeeded in obtaining a good balance between the target strength and low temperature toughness without the impairment of weld heat-affected zone toughness and weldability on site.

Further, when a weld heat-affected zone was heated to a temperature of not lower than 300°C, fine martensite-austenite (MA) was tempered and, therefore, a high Charpy absorbed energy was obtained stably. On the other hand, when a weld heat-affected zone of a steel to which Nb was added at not less than 0.01% was heated to a temperature of not lower than 300°C, though fine martensite-austenite (MA) was tempered, the brittlement occurred, at the same time, caused by the precipitation of Nb and therefore a conspicuous effect, as expected in the present invention, was not seen.

Next, the reasons for limiting the components of a steel plate and those of the base steel of a steel pipe are explained hereunder.

C is extremely effective for improving the strength and hardenability of a steel by the dissolution of C or the precipitation of carbonitride in the steel, and the lower limit of a C content is set at 0.02% in order to achieve a target strength by making a structure consist of bainite, martensite, or a bainite and martensite dominant structure. On the other hand, when a C content is excessive, low temperature toughness of a steel material and at a weld heat-affected zone deteriorates

and, thus, the weldability at a site deteriorates conspicuously, for example low temperature cracks occur after welding, and therefore the upper limit of a C content is set at 0.10%. It is preferable to set the upper limit of a C content at 0.07% to further improve low temperature toughness. Here, it is preferable to control a C content to not less than 0.03% for improving strength. On the other hand, if strength is too high, the shape of a steel pipe may be impaired after pipe expansion and the roundness may deteriorate, and therefore it is preferable to control the C content to less than 0.05%. Here, roundness is obtained by measuring the diameter of a steel pipe at plural portions, for example measuring the diameter passing through the center of a steel pipe at four portions apart from the seam-weld at an every angle of 45 degrees, calculating the average value, deducting the minimum diameter from the maximum diameter, and then dividing the deduction by the average value.

Si has the function of deoxidation and the effect of enhancing strength. However, when Si is added excessively, weld heat-affected zone toughness and weldability on site are remarkably deteriorated and therefore the upper limit of an Si content is set at 0.8%. A preferable upper limit of an Si amount is 0.6%. Here, as Al and Ti also have the function of deoxidation, like Si, in a steel according to the present invention, it is preferable to adjust an Si content according to the contents of Al and Ti. The lower limit of an Si content is not particularly specified but Si is generally contained by not less than about 0.01% as an impurity in a steel.

Mn is an indispensable element for making the microstructure of a steel according to the present invention consist of a bainite and martensite dominant structure and securing a good balance between strength and low temperature toughness, and thus the lower limit

of an Mn content is set at 1.5%. On the other hand, if Mn is added excessively, not only hardenability is increased and weld heat-affected zone toughness and weldability at a site are deteriorated, but also center segregation is accelerated and the low temperature toughness of a steel material is deteriorated. For those reasons, the upper limit of an Mn content is set at 2.5%. Here, center segregation means the state wherein the segregation of components generated caused by solidification in the vicinity of the center of a casting in a casting process does not disappear even after being subjected to the subsequent processes and remains in the vicinity of the center of the thickness of the steel plate.

P and S are inevitably included impurity elements. P accelerates center segregation and, at the same time, improves low temperature toughness by intergranular fracture. S lowers ductility and toughness by the influence of MnS, that elongates during hot rolling, in a steel. Therefore, in the present invention, the upper limits of a P content and an S content are set at 0.015% and 0.003% respectively for further improving low temperature toughness and weld heat-affected zone toughness. Note that, P and S are impurities and the lower limits of their contents are about 0.003% and 0.0001% respectively under current technology. Further, it is possible to suppress the precipitation of sulfide such as MnS in a steel by restricting an S content to not more than 0.001%. For that reason, it is preferable to restrict an S content to not more than 0.001% for suppressing the deterioration of ductility and toughness.

Ni, compared with Mn, Cr or Mo, is able to reduce a formation of a hardened structure which is harmful to low temperature toughness at a center segregation zone formed at hot rolling. Ni is also effective to increase toughness at weld heat-affected zone. Since the effects are insufficient with an Ni content of less than 0.01%,

the lower limit thereof is set at 0.01%. Further, it is preferable to set the lower limit of an Ni content at 0.3% for the improvement of weld heat-affected zone toughness. On the other hand, if an Ni content is excessive, not only the economical efficiency deteriorates because Ni is expensive but also weld heat-affected zone toughness and weldability at a site deteriorate, and therefore the upper limit of an Ni content is set at 2.0%. Note that, the addition of Ni is also effective in the prevention of surface cracks caused by Cu during continuous casting and hot rolling. When Ni is added for that purpose, it is preferable to add Ni to not less than one-third of the Cu content.

Mo is added for improving the hardenability of a steel and obtaining bainite, martensite, or a bainite and martensite dominant structure, those being excellent in a balance between strength and low temperature toughness. The effects are enhanced further by adding Mo in combination with the addition of B. Further, by the coexistence of Mo with B, the effects of suppressing the recrystallization of austenite during controlled rolling and thus fining an austenite structure are obtained. For obtaining those effects of Mo addition, the lower limit of an Mo content is set at 0.2% in the case of a steel to which B is not added, and the same is set at 0.1% in the case of a steel to which B is added. On the other hand, if Mo is added in excess of 0.8%, not only a production cost increases but also weld heat-affected zone toughness and weldability at a site deteriorate regardless of the addition of B. Therefore, the upper limit of an Mo content is set at 0.8%. Here, a preferable upper limit of an Mo content is 0.6%.

Nb suppresses the recrystallization of austenite during controlled rolling, makes an austenite structure fine by the precipitation of carbonitride, and also contribuies to the improvement of hardenability. In particular, the effect of the improvement of

hardenability by the addition of Nb is synergistically enhanced by its coexistence with B. However, if Nb is added to not less than 0.01%, coarse grains are partially generated, thus a percent fracture in an impact test is lowered and weld heat-affected zone toughness is deteriorated when double or more layer welding is applied. Further, in that case, weldability at a site is also deteriorated. For those reasons, the upper limit of an Nb content is set at less than 0.01%. A preferable Nb content is not more than 0.005%. Further, it is not necessary to add Nb as long as a P value defined by the expression P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5 is in the range from 1.9 to 4.0, preferably from 1.9 to 3.5, in a steel not containing B or a P value defined by the expression P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo is in the range from 2.5 to 4.0. However, Nb is usually contained at not less than 0.001% in a steel as an impurity.

Ti forms fine nitride in a steel and suppresses the coarsening of austenite during reheating. Further, in a B added steel, Ti reduces dissolved N that is harmful to the improvement of hardenability by fixing N as nitride and thus improves hardenability further. Furthermore, when an Al content is not more than 0.005%, Ti forms an oxide in a steel. The Ti oxide functions as intragranular transformation product nuclei at a weld heat-affected zone and thus makes the structure of the weld heat-affected zone fine. It is preferable to set the lower limit of a Ti content to 0.001% for securing the aforementioned effects of Ti addition. Further, it is preferable to regulate the lower limit of a Ti content to not less than 3.4N for stably obtaining the effects caused by the formation of nitride and the fixation of dissolved N. On the other hand, if an addition amount of Ti is excessive, nitride coarsens, fine carbide is generated, precipitation hardening occurs and, therefore, weld heat-affected zone toughness is deteriorated.

Further, in that case, as in the case where Nb is added to not less than 0.01%, coarse grains are partially generated and thus low temperature toughness is deteriorated. For those reasons, the upper limit of a Ti content is set at 0.030%.

Al is added in a steel as a deoxidizer and also has the function of fining a structure. However, if the Al content exceeds 0.1%, nonmetallic inclusions of an aluminium oxide system increase, thus the cleanliness of a steel is impaired, and also the toughness of a steel material and at a weld heat-affected zone is deteriorated. For those reasons, the upper limit of an Al content is set at 0.1%. A preferable upper limit thereof is 0.07% and the optimum Al content is not more than 0.06%. Further, as Si and Ti also have the same function of deoxidation as Al has, in a steel according to the present invention, it is preferable to control an Al content in consideration of the contents of Si and Ti. The lower limit of an Al content is not specified, but Al is usually contained at not less than 0.005%.

N, when it is added in excess of 0.008%, generates surface defects on a casting and causes the deterioration of weld heat-affected zone toughness by dissolved N and Nb nitride. Therefore, the upper limit of an N content is set at 0.008%. A preferable upper limit of an N content is 0.006%. The lower limit of an N content is not specified because the lower the N content, the better, but N is usually contained at about 0.003% as an impurity.

A steel according to the present invention contains the components explained above as basic components. In addition, for contriving to further improve strength and toughness and expand the producible size of steel materials, one or more of B, V, Cu, Cr, Ca, REM and Mg may be added to the contents specified below.

B is an element effective in enhancing the hardenability of a steel by adding a trace amount of B

and in obtaining a bainite and/or martensite dominant structure that is one of the objects of the present invention. Further, B enhances the effect of Mo in improving the hardenability of a steel according to the present invention and accelerates the effect of improving hardenability synergistically by the coexistence of B with Nb. Those effects are not secured when the B content is less than 0.0003%. Therefore, the lower limit of a B content is set at 0.0003%. On the other hand, if B is added excessively, not only is the formation of brittle grains such as $Fe_{23}(C,B)_6$ accelerated and, thus, low temperature toughness is deteriorated but, also, the effect of B in improving hardenability is impaired. Therefore, the upper limit of a B content is set at 0.0030%.

V has almost the same function as Nb has. Though the effects of V are weaker than those of Nb with a single addition of V, the coexistence of V with Nb further enhances the effects of improving low temperature toughness and weld heat-affected zone toughness. Since those effects are insufficient with a V content of less than 0.001%, it is preferable to set the lower limit thereof to 0.001%. On the other hand, if the addition amount of V exceeds 0.3%, weld heat-affected zone toughness, particularly weld heat-affected zone toughness when double or more layer welding is applied, is deteriorated, coarse grains caused by abnormal ferrite/austenite transformation during heating for hot rolling are generated, thus low temperature toughness is deteriorated and, further, weldability on site is impaired. For those reasons, it is preferable to set the upper limit of a V content at 0.3%. A still preferable upper limit of a V content is 0.1%.

Cu and Cr are elements that enhance strength of a base steel and at a weld heat-affected zone, and it is necessary to contain them at not less than 0.01% respectively to obtain those effects. On the other hand,

if the content of Cu or Cr is excessive, weld heat-affected zone toughness and weldability on site are deteriorated considerably. Therefore, each of the upper limits of the contents of Cu and Cr is set at 1.0%.

Ca and REM have the functions of controlling the shape of sulfide such as MnS in a steel and improving the low temperature toughness of the steel. It is preferable to set each of the lower limits of the contents of Ca and REM at 0.0001%. On the other hand, if Ca is added in excess of 0.01% or REM in excess of 0.02%, CaO-CaS or REM-CaS is generated in large quantities, which forms large clusters and large inclusions and, thus, the cleanliness of a steel is impaired and weldability on site is deteriorated. For those reasons, it is preferable to set the upper limits of the contents of Ca and REM at 0.01% and 0.02% respectively. Further, a still preferable upper limit of a Ca content is 0.006%.

In addition, when a strength of not lower than 950 MPa is required, it is preferable to further regulate the contents of S and O in a steel to 0.001% and 0.002% respectively. Furthermore, it is preferable to control an ESSP value, that is an index related to the shape control of sulfide system mixtures, (ESSP being defined by the expression ESSP = (Ca)[1 - 124(O)]/ 1.25S) in the range from 0.5 to 10.0.

Mg has the functions of forming finely dispersed oxide, suppressing the coarsening of austenite grains at a weld heat-affected zone, and thus improving low temperature toughness. The lower limit of an Mg content is set at 0.0001% for securing those effects. On the other hand, if an Mg content exceeds 0.006%, coarse oxide is generated and thus low temperature toughness is deteriorated. Therefore, the upper limit of an Mg content is set at 0.006%.

In addition to the limitation on the content of each of the addition elements, the present invention regulates a P value, that is an index of hardenability within an

appropriate range, to obtaining an excellent balance between strength and low temperature toughness. A P value is defined differently according to the presence of B in a steel: in a steel not containing B, a P value is defined by the expression $P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5$; and in a steel containing B, a P value is defined by the expression $P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo$. When a P value is less than 1.9 in a steel without B addition or less than 2.5 in a steel with B addition, tensile strength of not lower than 800 MPa is not obtained, and therefore those values are determined to be the lower limits in respective steels. On the other hand, when a P value exceeds 4.0 in either of the steels, weld heat-affected zone toughness and weldability at a site are deteriorated, and therefore the value is determined to be the upper limit in either of the steels. Furthermore, it is preferable to determine the upper limit of a P value to be 3.5 in a steel without B addition. In conclusion, an adequate range of a P value is determined to be: from 1.9 to 4.0, preferably from 1.9 to 3.5, in a steel without B addition; and from 2.5 to 4.0 in a steel with B addition.

Next, a microstructure is explained hereunder.

To attain a high strength of not lower than 800 MPa in terms of tensile strength and securing good low temperature toughness, it is necessary to control the amount of bainite, martensite, or a bainite and martensite dominant structure in the range from 90 to 100% in terms of a bainite and martensite fraction. Note that, the balance seems to be retained austenite, but it is hard to identify with an optical microscope. Here, that a bainite and martensite fraction is in the range from 90 to 100% is defined by the following two conditions. Firstly, (1) confirming that polygonal ferrite is not generated by an optical micrograph, a scanning electron micrograph, or a transmission electron

micrograph, and secondly, (2) defining that a bainite and martensite fraction is in the range from 90 to 100% as follows according to hardness: to calculate the hardness of 100% martensite from the amount of C using the expression Hv = 270 + 1,300C, wherein C is the amount of C expressed in terms of mass percent; and when the hardness of a steel material is in the range from 70 to 100% of the hardness of the 100% martensite, it is defined that the bainite and martensite fraction of the steel material is in the range from 90 to 100%.

In addition, when a bainite and martensite fraction is in the range from 90 to 100%, tensile strength and a C amount satisfy the following expression: 0.7 x (3,720C + 869) < TS, wherein TS is tensile strength [in terms of MPa] of a steel obtained and C is a C amount [in terms of mass percent].

For obtaining excellent low temperature toughness in the direction of a cross section in the case of a steel pipe for a line pipe for example, it is necessary to optimize an austenite phase before the austenite phase transforms into a ferrite phase, or what is called the structure of prior austenite, at the time of cooling, and to make the final structure of a steel material efficiently fine. For that reason, prior austenite is required to consist of unrecrystallized austenite and also the average grain diameter thereof is limited to not larger than 10 μm. By so doing, extremely good balance between strength and low temperature toughness is obtained. Here, the diameter of prior austenite grains means the diameter of grains including a deformation band and a twin boundary that have the same function as an austenite grain boundary. The diameter of prior austenite grains is determined, for example in conformity with JIS G 0551, by dividing the full length of a straight line drawn in the direction of the steel sheet thickness by the number of the points where the straight line intersects with the grain boundaries of the prior

austenite existing on the straight line, by using an optical micrograph. The lower limit of the average diameter of prior austenite grains is not specified, but the detectable lower limit is about 1 μm according to a test with an optical micrograph. Here, a preferable range of a prior austenite grain diameter is from 3 to 5 μm.

In the production of a high-strength steel excellent in low temperature toughness according to the present invention, it is desirable to carry out hot rolling under the conditions described below. A reheating temperature is determined to be in a temperature range wherein the structure of a casting substantially consists of a single austenite phase, namely the Ac_3 point is determined to be the lower limit of a reheating temperature. When a reheating temperature exceeds 1,300°C, crystal grains coarsen and, therefore, it is preferable to limit a reheating temperature to not higher than 1,300°C. With regard to rolling after the reheating, it is preferable to firstly carry out recrystallization rolling and secondly carry out unrecrystallization rolling. Note that, though a recrystallization temperature varies according to steel components, it is in the range from 900°C to the reheating temperature, and therefore the preferable temperature range during recrystallization rolling is from 900°C to 1,100°C and the preferable temperature range during unrecrystallization rolling is from 750°C to 880°C. Thereafter, cooling is applied at a cooling rate of not lower than 1°C/sec. up to an arbitrary temperature of not higher than 550°C. The upper limit of a cooling rate is not particularly specified, but a preferable range thereof is from 10 to 40°C/sec. The lower limit of a cooling end temperature is neither particularly specified, but a preferable range thereof is from 200°C to 450°C.

By carrying out hot rolling under such conditions of

steel components, heating and rolling as explained above, a ultra-high-strength steel sheet excellent in low temperature toughness can be obtained. Further, by cold-forming the hot-rolled steel plate into a pipe and thereafter applying double or more layer seam welding to an abutted portion, a ultra-high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness can be produced. That is, by the present invention, it is made possible to mitigate welding conditions in the production of a steel pipe having such a sheet thickness when double or more layer welding is required. It is preferable to employ arc welding, particularly submerged arc welding, for seam welding.

The size of a high-strength steel pipe used for a line pipe according to the present invention is usually about 450 to 1,500 mm in diameter and about 10 to 40 mm in wall thickness. As a method for producing a steel pipe of such a size efficiently, the production method preferably includes the processes of: producing a pipe in a UO process where a steel plate is formed into a U-shape and then into an O-shape; tack-welding the abutted portion; thereafter applying submerged arc welding from the inner and outer sides, and thereafter securing roundness by pipe expansion.

Submerged arc welding is the one wherein the dilution of a weld metal by a base steel is large. Therefore, for controlling the chemical components of a weld metal in a range wherein desired properties are obtained, it is necessary to select a weld material in consideration of the dilution by a base steel. As an example, welding may be carried out by using: a weld wire containing Fe as the main component, 0.01 to 0.12% C, not more than 0.3% Si, 1.2 to 2.4% Mn, 4.0 to 8.5% Ni, and 3.0 to 5.0 % Cr + Mo + V; and a flux of a agglomerated type or a fused type.

The ratio of dilution by a base steel varies

depending on welding conditions, particularly a weld heat input, and, in general, the ratio of dilution by a base steel increases with the increase of a heat input. However, under the condition of slow welding speed, the ratio of dilution by a base steel does not increase even when a heat input increases. For securing sufficient weld penetration when one pass welding is applied to an abutted portion from the outer side and the inner side thereof, it is preferable to limit a heat input and a welding speed to the following ranges.

When a heat input is less than 2.5 kJ/mm, weld penetration decreases but, on the other hand, when a heat input is larger than 5.0 kJ/mm, a weld heat-affected zone softens and weld heat-affected zone toughness somewhat deteriorates. Therefore, it is preferable to limit a heat input in the range from 2.5 to 5.0 kJ/mm.

When a welding speed is lower than 1 m/min., the welding work is somewhat inefficient as seam welding for a line pipe but, on the other hand, when a welding speed exceeds 3 m/min., a bead shape is hardly stable. Therefore, it is preferable to limit a welding speed in the range from 1 to 3 m/min.

Roundness can be improved by applying pipe expansion after seam welding. It is preferable to set a pipe expansion rate at not less than 0.7% for improving roundness by applying plastic deformation. On the other hand, if a pipe expansion rate exceeds 2%, the toughness of both a base steel and a weld deteriorates to some extent caused by plastic deformation. For those reasons, it is preferable to determine a pipe expansion rate to be in the range from 0.7 to 2%. Here, a pipe expansion rate is defined by the value obtained by subtracting a circumference before pipe expansion from a circumference after pipe expansion, dividing the resulting value by the circumference before pipe expansion, and expressing the resulting value as a percentage.

After seam welding, when a seam weld is heated to

not lower than 300°C before and/or after pipe expansion, a massive mixture of martensite and austenite (referred to as "MA") generated at a weld heat-affected zone can be decomposed into a bainite and martensite dominant structure and fine hard cementite and, therefore, weld heat-affected zone toughness improves. On the other hand, if a heating temperature exceeds 500°C, a base steel softens. For those reasons, it is preferable to limit the heating temperature in the range from 300°C to 500°C. Though the influence of time is not large, it is preferable that the time is about 30 seconds to 60 minutes. A preferable range thereof is about 30 seconds to 50 minutes. Further, when heating is applied after pipe expansion, a processing strain converging at the toe of a weld recovers and thus weld heat-affected zone toughness improves.

When a test piece is cut out from a weld heat-affected zone, specularly polished and etched, and then observed with a scanning electron microscope, it is seen that an MA formed at a weld heat-affected zone is entirely composed of a white massive substance. When an MA is heated to 300°C to 500°C, it is decomposed into a bainite and martensite dominant structure having fine precipitates in the grains and cementite, and these can be distinguished from the MA. Further, when a test piece is subjected to repeller etching or nitral etching after specularly polished and observed with a scanning electron microscope too, an MA can be distinguished from another MA decomposed into a bainite and martensite dominant structure and cementite by judging whether or not fine precipitates exist in grains.

Here, when a seam weld is heated, it is preferable to apply the heating to a weld metal and the weld heat-affected zone of a base steel. A weld heat-affected zone is the area within about 3 mm from an intersection of a weld metal and a base steel and therefore it is preferable to heat at least the area including a base

steel within 3 mm from an intersection of a weld metal and a base steel. However, it is technically difficult to heat such a narrow area and therefore it is realistic to apply a heat treatment to the area within about 50 mm from an intersection of a weld metal and a base steel. Here, there is no inconvenience such as the deterioration of base steel properties caused by a heating to a temperature in the range from 300°C to 500°C. A gas burner of a radiation type or an induction heater can be adopted for the heating of a seam weld.

As it has been explained above, the present invention makes it possible to produce a ultra-high-strength steel plate having a tensile strength of not lower than 800 MPa and a steel pipe made thereof: the steel plate being excellent in weld heat-affected zone toughness when double or more layer welding is applied; Charpy absorbed energy of the base steel in the temperature range of not higher than -40°C being not lower than 200 J on the average and little dispersing; the steel plate having excellent low temperature toughness; and further the steel plate being excellent in weldability at a site. By so doing, it is made possible to apply the steel plate and the steel pipe for a line pipe for the transport of natural gas or crude oil, a steel plate for water pumping, a pressure vessel, a welded structure or the like, these being used in harsh environments.

Example 1

Steels containing chemical compositions shown in Tables 1 and 2 (Table 2 being continued from Table 1) were melted and continuously cast into castings 240 mm in thickness. The resulting castings were reheated to 1,100°C, thereafter rolled in the recrystallization temperature range from 900°C to 1,100°C, further rolled in the uncrystallization temperature range from 750°C to 880°C, and thereafter cooled at a cooling rate of 5 to 50°C/sec. up to a temperature not higher than 420°C by

water cooling, and by so doing, steel plates 10 to 20 mm in thickness were produced.

An average diameter of prior austenite grains was obtained by the straight line crossing segment method in the thickness direction conformity with JIS G 0551. A bainite and martensite fraction was obtained by the following procedures. To begin with, it was confirmed that polygonal ferrite was not generated by observing a structure in an optical micrograph in conformity with JIS G 0551. Then, the Vickers hardness was measured imposing a weight of 1 Kg and the measured value was defined as Hv_{BM} in conformity with JIS Z 2244. The ratio α_{BM} of Hv_{BM} to the hardness of 100% martensite calculated by the expression Hv = 270 + 1,300C, namely $Hv_{BM}/Hv = \alpha_{BM}$, was obtained. Thereafter, using the definition of a bainite and martensite fraction being 90% in the event of α_{BM} = 0.7 and the same being 100% in the event of α_{BM} = 1, a bainite and martensite fraction F_{BM} was calculated by the expression $F_{BM} = 100 \times (1/3 \times \alpha_{BM} + 2/3)$.

Yield strength and tensile strength in the direction of the rolling of a steel plate (hereunder referred to as "L direction") and in the direction perpendicular to the rolling direction (hereunder referred to as "C direction") were evaluated by the API full thickness tensile test. A Charpy impact test was carried out at -40°C with the test repetition frequency n being three in conformity with JIS Z 2242 by using V-notched test pieces of a standard size, the length of the test pieces being in the L and C directions, prepared in conformity with JIS Z 2202. A Charpy absorbed energy was evaluated as the average of the values obtained by the three repeated measurements. In addition, another Charpy impact test was carried out in the temperature range from -60°C to lower than -40°C with the test repetition frequency n varied from 3 to 30, and the probability that a Charpy

absorbed energy is not lower than 200 J (hereunder referred to as "low temperature toughness reliability") was evaluated in terms of percentage.

Weld heat-affected zone toughness was evaluated by subjecting a specimen to heat treatments corresponding to welding twice, each welding having a heat input of 2.5 kJ/mm, using a weld reproducing heat cycle test apparatus. That is, the first heat treatment was applied to a specimen under the conditions that the specimen was heated at a heating rate of 100°C/sec. to a temperature of 1,400°C, retained at the temperature for one second, and thereafter cooled at a cooling rate of 15°C/sec. in the temperature range from 500°C to 800°C, and, in addition to that, the second heat treatment was applied thereto under the conditions that the heating temperature was set at 1,400°C or 900°C with the conditions of heating rate, retention time, cooling temperature and cooling rate being identical to the first heat treatment. Further, V-notched test pieces of standard dimension were prepared in conformity with JIS Z 2202, and the Charpy impact test was applied to the test pieces at -30°C with the repetition frequency n being three in conformity with JIS Z 2242, and Charpy absorbed energy was evaluated by the average of the values obtained by the three repeated measurements.

The results are shown in Table 3. Steels A to E are the ones that contain components within the ranges specified in the present invention and fulfill the target levels of strength, low temperature toughness and weld heat-affected zone toughness. On the other hand, steel F has a C amount and steel I an Mn amount smaller than those in the ranges specified in the present invention and therefore the strength is low. Steel G has a C amount, steel H an Si amount, steel J an Mn amount, and steel K an Mo amount larger than those in the ranges specified in the present invention and therefore low temperature toughness, low temperature toughness

reliability and weld heat-affected zone toughness are deteriorated. Steel L has an Nb amount larger than that in the range specified in the present invention, and therefore, though the Charpy absorbed energy at -40°C is good, low temperature toughness reliability and weld heat-affected zone toughness are deteriorated. Steel M has a still larger Nb amount than steel L and therefore low temperature toughness, low temperature toughness reliability and weld heat-affected zone toughness are deteriorated. Steels N, O, P and R have a Ti amount, a V amount, an N amount and an S amount, respectively, larger than those in the ranges specified in the present invention, and therefore, low temperature toughness, low temperature toughness reliability and weld heat-affected zone toughness are deteriorated. Steel Q has an Al amount larger than that in the range specified in the present invention and therefore weld heat-affected zone toughness is deteriorated.

Table 1: Chemical components (mass percent), Ceq and Pcm of steel material

Steel	Chemical components (mass percent)										
	C	Si	Mn	P	S	Ni	Mo	Nb	Ti	Al	N
A	0.03	0.10	1.95	0.005	0.0005	0.50	0.30	0.005	0.008	0.015	0.0023
B	0.05	0.25	1.85	0.008	0.0006	0.90	0.45	0.007	0.005	0.020	0.0015
C	0.04	0.15	1.90	0.003	0.0008	2.00	0.20	0.009	0.010	0.008	0.0030
D	0.06	0.25	1.90	0.004	0.0003	1.80	0.40	0.003	0.009	0.010	0.0025
E	0.05	0.10	1.96	0.004	0.0010	1.00	0.10	0.009	0.005	0.020	0.0015
F	0.01	0.25	1.85	0.005	0.0010	1.20	0.35	0.004	0.011	0.015	0.0032
G	0.15	0.15	1.95	0.007	0.0006	0.60	0.26	0.007	0.011	0.012	0.0033
H	0.07	1.00	2.12	0.009	0.0018	0.30	0.48	0.009	0.011	0.023	0.0032
I	0.04	0.26	1.00	0.010	0.0026	0.50	0.52	0.002	0.009	0.015	0.0025
J	0.05	0.35	3.00	0.006	0.0003	0.32	0.42	0.001	0.005	0.026	0.0016
K	0.09	0.48	2.05	0.008	0.0005	0.85	1.00	0.005	0.010	0.023	0.0030
L	0.04	0.55	1.98	0.009	0.0016	0.13	0.26	0.050	0.010	0.015	0.0028
M	0.04	0.55	1.96	0.009	0.0016	0.13	0.26	0.150	0.010	0.015	0.0028
N	0.03	0.49	1.91	0.005	0.0006	0.45	0.32	0.003	0.035	0.010	0.0016
O	0.07	0.15	2.00	0.006	0.0007	0.50	0.23	0.002	0.012	0.030	0.0035
P	0.08	0.05	2.16	0.007	0.0009	0.16	0.51	0.005	0.015	0.026	0.0080
Q	0.05	0.16	1.79	0.009	0.0005	0.65	0.45	0.006	0.012	0.060	0.0035
R	0.04	0.20	1.95	0.007	0.0040	0.80	0.30	0.008	0.010	0.001	0.0030

A bar - in a cell of a chemical component means that the amount thereof is not larger than the detectable limit.

$$Ceq = C/ + Mn/6 + (Ni + Cu)/5 + (Mo + V + Cr)/5$$

$$Pcm = C + Si/30 + (Mn + Cu + Cr)/20 + Ni/60 + Mo/15 + V/10 + B + 5$$

$$P\ value = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5 (B\ free\ steel)$$

$$P\ value = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo (B\ containing\ steel)$$

Table 2 - (continued from Table 1)

Chemical components (mass percent)							P-value	Ceq	Pcm
B	V	Cu	Cr	Ca	REM	Mg			
0.0010	0.080	0.30	0.30	-	-	-	3.24	0.540	0.200
-	-	0.50	0.60	0.0012	-	0.0010	3.15	0.662	0.251
0.0023	0.040	-	-	-	0.0008	-	3.35	0.538	0.202
-	0.050	0.30	0.30	-	-	-	3.35	0.667	0.255
0.0010	-	-	0.60	-	-	-	3.22	0.583	0.210
0.0010	0.030	0.30	0.30	-	-	0.0005	3.48	0.554	0.192
0.0008	-	0.23	0.50	-	-	-	3.58	0.682	0.320
-	0.040	0.16	0.50	-	0.0008	-	3.38	0.658	0.283
0.0008	0.030	0.65	0.32	-	-	-	2.83	0.457	0.197
0.0015	0.026	0.26	0.45	0.002	-	-	4.58	0.768	0.291
0.0016	-	0.32	0.26	-	-	-	4.72	0.762	0.326
0.0013	0.050	0.15	0.52	-	-	-	3.32	0.551	0.221
0.0013	0.050	0.15	0.52	-	-	-	3.32	0.551	0.221
0.0010	0.030	0.51	0.23	0.0023	-	0.0002	3.34	0.528	0.215
-	0.150	0.30	0.42	-	-	-	2.98	0.617	0.250
0.0026	0.040	0.23	0.26	-	0.0005	-	3.82	0.628	0.268
0.0023	-	0.32	0.59	0.0021	-	-	3.57	0.621	0.243
0.0008	0.050	0.30	0.30	-	-	-	3.42	0.568	0.217

Table 3: Evaluation result

Performance No.	Steel	Mechanical properties of steel material			Low temperature toughness reliability,	Average prior austenite grain diameter,	Bainite and martensite fraction,	Weld heat-affected zone toughness	
		YS	TS	vE-40				Condition 1,	Condition 2,
		MPa	MPa	J	%	μm	%	J	J
1	A	890	1000	280	95	4.5	100	130	110
2	B	917	1030	230	93	5.1	100	125	105
3	C	872	980	290	96	4.2	100	162	142
4	D	904	1016	245	97	6.1	100	156	136
5	E	908	1020	225	94	4.6	100	166	146
6	F	703	790	210	86	7.5	81	140	130
7	G	1113	1250	56	75	4.6	100	65	45
8	H	966	1085	80	79	7.5	100	43	23
9	I	694	780	205	86	4.3	80	130	110
10	J	1077	1210	60	75	4.5	100	80	60
11	K	1028	1155	150	82	5.3	100	82	62
12	L	908	1020	205	84	6.2	100	75	55
13	M	1086	1220	80	80	4.3	100	45	25
14	N	890	1000	85	82	5.2	100	65	45
15	O	1041	1170	150	82	4.6	100	75	55
16	P	1050	1180	130	82	5.2	100	50	30
17	Q	908	1020	200	85	3.8	100	66	46
18	R	890	1000	80	80	3.2	100	45	25

vE-40 is Charpy absorbed energy measured at -40°C with the repetition frequency n being three.

Weld heat-affected zone toughness is Charpy absorbed energy measured at -30°C with the repetition frequency n being three.

The conditions of weld heat-affected zone toughness are identical to the heat treatment conditions of weld reproducing heat cycle test.

Heating rate: 100°C/sec., retention time: 1 sec., cooling temperature range: 500°C to 800°C, cooling rate: 15°C/sec.

Condition 1: both first and second heating temperatures are 1,400°C.

Condition 2: first heating temperature is 1,400°C and second is 900°C.

Example 2

Steel plates 10 to 20 mm in thickness, the steel sheets containing the chemical components of steels A to E shown in Tables 1 and 2, were produced under the same conditions as Example 1. Thereafter, the steel plates were subjected to cold forming, then submerged arc welding at a heat input of 2.0 to 3.0 kJ/mm on each of the inner surfaces and at a heat input of 2.0 to 3.0 kJ/mm on each of the outer surfaces, thereafter pipe expansion, and, by so doing, steel pipes 700 to 920 mm in outer diameter were produced. An average diameter of prior austenite grains and a bainite and martensite fraction in the base steel of each of the steel pipes were obtained in the same manner as Example 1. Further, tensile properties of each of the steels were evaluated by the API full thickness tensile test. Low temperature toughness was evaluated, as in Example 1, by the average value of absorbed energy and the low temperature toughness reliability of a Charpy impact test piece prepared so that the length thereof may be in the C direction. Weld heat-affected zone toughness was evaluated by subjecting a test piece having a notch at an intersection or a portion 1 mm apart from an intersection to another Charpy impact test at -30°C.

The results are shown in Table 4. In any of the steels, the tensile strength of the base steel is not lower than 800 MPa, the toughness of the base steel is extremely good; the Charpy absorbed energy at -40°C is not lower than 200 J and the low temperature toughness reliability is not less than 85%. With respect to a weld heat-affected zone, the Charpy absorbed energy at -30°C is not lower than 100 J and the weld heat-affected zone toughness is also excellent.

Table 4: Evaluation result

Performance No.	Steel	Mechanical properties of steel pipe			Low temperature toughness reliability, %	Average prior austenite grain diameter, µm	Bainite and martensite fraction, %	Weld heat-affected zone toughness	
		YS MPa	TS MPa	vE-40 J				Notch position 1, J	Notch position 2, J
19	A	917	1030	260	90	4.5	100	205	175
20	B	935	1050	210	93	5.1	100	180	150
21	C	890	1000	270	94	4.2	100	162	132
22	D	922	1036	225	90	6.1	100	145	115
23	E	935	1050	215	86	4.6	100	148	118

Notch position 1 means a mating portion and notch position 2 means a portion 1 mm away from a mating portion.

Example 3

In the same manner as Example 1, castings were produced from a steel containing chemical components of steel A shown in Tables 1 and 2 and, thereafter, the castings were hot rolled under the conditions shown in Table 5 and cooled and, by so doing, steel plates 10 to 20 mm in thickness were produced. In the same manner as Example 1, an average diameter of prior austenite grains and a bainite and martensite fraction were obtained, and tensile properties were evaluated by the API full thickness tensile test. Low temperature toughness was evaluated, as for Example 1, by the average value of absorbed energy and the low temperature toughness reliability of a Charpy impact test piece prepared so that the length thereof may be in the C direction. Weld heat-affected zone toughness was evaluated by subjecting a test piece to a weld-reproducing heat cycle test and then a Charpy impact test at -30°C.

The results are shown in Table 6. In any of the steels, the tensile strength of the base steel is not lower than 800 MPa, with respect to the toughness of the base steel, the Charpy absorbed energy at -40°C is not lower than 200 J and the low temperature toughness reliability is not less than 85% and, with respect to the weld heat-affected zone, the Charpy absorbed energy at -30°C is not lower than 100 J and, therefore, an ultra-high-strength steel plate excellent in weld heat-affected zone toughness is obtained. Further, steels 27 and 28 produced under the conditions in the ranges specified in claim 6 have more excellent low temperature toughness reliability than steels 24 to 26 produced under conditions different from those specified in claim 6.

Table 5: Hot-rolling condition

Performance No.	Steel	Hot-rolling condition						
		Heating temperature, °C	Recrystallization rolling		Unrecrystallization rolling		Water cooling	
			Start temperature, °C	End temperature, °C	Start temperature, °C	End temperature, °C	Stop temperature, °C	Cooling rate, °C/sec.
24	A	1350	900	850	830	730	400	20
25	A	1100	980	930	850	810	600	20
26	A	1100	960	900	880	800	200	0.5
27	A	1150	970	930	850	790	350	40
28	A	1100	1000	950	870	780	400	15

Table 6: Evaluation result

Performance No.	Mechanical properties of steel material				Low temperature toughness reliability,	Average prior austenite grain diameter,	Bainite and martensite fraction,	Weld heat-affected zone toughness	
	Steel	YS	TS	vE-40				Condition 1,	Condition 2,
		MPa	MPa	J	%	μm	%	J	J
24	A	872	980	210	85	5.1	100	205	175
25	A	792	890	205	88	4.5	93	210	180
26	A	757	850	210	87	4.8	91	202	172
27	A	890	1000	260	95	3.5	100	223	193
28	A	872	980	250	96	4.2	100	215	185

vE-40 is Charpy absorbed energy measured at -40°C with the repetition frequency n being three.

Weld heat-affected zone toughness is Charpy absorbed energy measured at -30°C with the repetition frequency n being three.

The conditions of weld heat-affected zone toughness are identical to the heat treatment conditions of weld reproducing heat cycle test.

Heating rate: 100°C/sec., retention time: 1 sec., cooling temperature range: 500°C to 800°C, cooling rate: 15°C/sec.

Condition 1: both first and second heating temperatures are 1,400°C.

Condition 2: first heating temperature is 1,400°C and second is 900°C.

Example 4

Steels containing chemical compositions shown in Table 7 were melted and continuously cast into castings. The resulting castings were reheated to 1,100°C, thereafter rolled in the recrystallization temperature range from 900°C to 1,100°C, further rolled at a reduction ratio of 5 in the uncrystallization temperature range from 750°C to 880°C, and thereafter cooled at a cooling rate of 5 to 50°C/sec. up to a temperature not higher than 420°C by water cooling and, by so doing, steel sheets 16 mm in thickness were produced. An average diameter of prior austenite grains was obtained by the straight line crossing segment method in conformity with JIS G 0551.

Yield strength and tensile strength in the C direction of a steel sheet were evaluated by the API full thickness tensile test. A Charpy absorbed energy was evaluated by carrying out a Charpy impact test at -40°C with the test repetition frequency n being three in conformity with JIS Z 2242 by using V-notched test pieces of a standard size, the length of the test pieces being in the C direction, prepared in conformity with JIS Z 2202. Weld heat-affected zone toughness was evaluated in the same manner as Example 1. In addition, for simulating HAZ thermal cycle, specimens were subjected to heat treatment twice, then heated to 350°C and held for five minutes at the temperature.

Further, the value TS/0.7(3,720C + 869) was calculated from a value of tensile strength and a C amount. When a bainite and martensite fraction is within the range from 90 to 100%, the following expression is satisfied;

$$TS/(3{,}720C + 869) > 0.7,$$

wherein TS is tensile strength of a steel obtained (in terms of MPa) and C is a C amount (in terms of mass percent).

In Table 8, steels AA to AF, AH, AJ, AK, and AP to

AR are the ones that contain components within the ranges specified in the present invention, and have the target levels of strength, low temperature toughness and weld heat-affected zone toughness. On the other hand, steel AG has a C amount larger than that in the range specified in the present invention and therefore the low temperature toughness of the base steel and the weld heat-affected zone toughness are deteriorated. Further, steel AI has an Mn amount smaller than that in the range specified in the present invention and therefore the microstructure does not consist of a bainite and martensite dominant structure and the strength and the low temperature toughness are deteriorated. Steels AL and AM have an Nb amount and steel AN a Ti amount larger than those in the ranges specified in the present invention and, therefore, coarse crystal grains are partially generated, the Charpy absorbed energy of the base steel is deteriorated in some of the test pieces, and also the weld heat-affected zone toughness is deteriorated. Steel AO has a P value smaller than that in the range specified in the present invention and therefore the tensile strength is deteriorated.

Table 7: Chemical components of steel material (mass percent)

Steel	Chemical components (mass percent)																	P-value
	C	Si	Mn	P	S	Ni	Mo	Nb	Ti	Al	N	B	V	Cu	Cr	Ca	REM	Mg	
AA	0.03	0.10	1.95	0.005	0.0005	0.50	0.30	0.005	0.009	0.015	0.0023	0.0011	0.060	0.30	0.30	-	-	-	3.24
AB	0.05	0.25	1.85	0.008	0.0006	0.90	0.45	0.007	0.005	0.020	0.0015	-	-	0.50	0.60	0.0012	-	0.0010	3.15
AC	0.04	0.15	1.90	0.003	0.0008	1.91	0.20	0.004	0.012	0.008	0.0030	0.0017	-	-	-	-	-	-	3.23
AD	0.06	0.25	1.90	0.004	0.0003	1.80	0.40	0.003	0.009	0.010	0.0025	-	0.050	0.30	0.30	-	-	-	3.35
AE	0.05	0.10	1.96	0.004	0.0010	1.00	0.10	0.009	0.007	0.020	0.0016	0.0010	-	-	0.60	-	-	-	3.22
AF	0.02	0.25	1.85	0.005	0.0010	1.20	0.35	0.004	0.011	0.015	0.0032	0.0013	0.030	0.30	0.30	-	-	0.0005	3.50
AG	0.15	0.15	1.60	0.007	0.0006	0.60	0.26	0.007	0.014	0.012	0.0033	0.0008	-	0.00	0.00	-	-	-	2.73
AH	0.07	0.54	2.12	0.009	0.0018	0.30	0.48	0.009	0.014	0.023	0.0032	-	0.040	0.16	0.50	-	0.0008	-	3.19
AI	0.04	0.26	1.00	0.010	0.0026	0.50	0.52	0.002	0.009	0.015	0.0025	0.0008	0.030	0.65	0.32	-	-	-	2.83
AJ	0.05	0.35	2.20	0.006	0.0003	0.32	0.42	0.001	0.005	0.026	0.0016	0.0015	0.026	0.26	0.45	0.002	-	-	3.78
AK	0.09	0.48	2.05	0.008	0.0005	0.85	0.64	0.005	0.013	0.023	0.0030	0.0000	-	0.00	0.00	-	-	-	3.83
AL	0.04	0.55	1.96	0.009	0.0016	0.13	0.26	0.042	0.012	0.015	0.0028	0.0013	0.050	0.15	0.52	-	-	-	3.32
AM	0.04	0.55	1.96	0.009	0.0016	0.13	0.26	0.079	0.014	0.015	0.0028	0.0013	0.050	0.15	0.52	-	-	-	3.32
AN	0.03	0.48	1.91	0.005	0.0006	0.45	0.32	0.003	0.064	0.010	0.0016	0.0010	0.030	0.51	0.23	0.0023	-	0.0002	3.34
AO	0.04	0.15	1.60	0.006	0.0007	0.10	0.23	0.002	0.012	0.030	0.0035	-	0.000	0.30	0.00	-	-	-	1.68
AP	0.08	0.05	2.20	0.007	0.0009	0.16	0.51	0.005	0.015	0.026	0.0025	0.0000	0.240	0.00	0.00	-	0.0005	-	3.75
AQ	0.04	0.16	1.79	0.009	0.0005	0.65	0.72	0.006	0.013	0.062	0.0035	0.0016	-	0.00	0.00	0.0021	-	-	3.33
AR	0.04	0.20	1.95	0.007	0.0012	0.80	0.30	0.008	0.012	0.001	0.0030	0.0008	0.000	0.00	0.00	-	-	-	2.95

A bar - in a cell of a chemical component means that the amount thereof is not larger than the detectable limit.

P value = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5(B free steel)

P value = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo(B containing steel)

Table 8: Test conditions and evaluation result

Performance No.	Steel	Mechanical properties of steel				Average prior austenite grain diameter,	TS/ (3720[C] + 869)	Weld heat-affected zone toughness			
		TS	vE-40					Condition 1	Condition 2	Condition 3	Condition 4
		MPa	J	J	J	μm		J	J	J	J
29	AA	930	280	276	281	4.5	0.948	134	110	138	162
30	AB	946	230	241	208	5.1	0.897	133	105	154	129
31	AC	980	290	277	281	4.2	0.963	156	142	180	174
32	AD	1016	221	205	198	6.1	0.930	153	136	175	151
33	AE	1020	225	204	212	4.6	0.967	165	146	179	188
34	AF	830	233	245	242	7.5	0.880	141	130	159	148
35	AG	1202	96	102	111	4.6	0.842	51	23	51	34
36	AH	1021	211	203	199	7.5	0.904	117	101	127	127
37	AI	698	164	157	123	4.3	0.686	87	110	100	111
38	AJ	1012	214	222	231	4.5	0.959	122	102	147	176
39	AK	1155	203	201	203	5.3	0.959	124	103	151	142
40	AL	987	242	64	202	6.2	0.970	87	55	88	43
41	AM	998	228	76	102	4.3	0.981	67	25	60	25
42	AN	931	85	243	221	5.2	0.949	65	45	64	22
43	AO	724	156	143	161	4.6	0.711	69	55	88	57
44	AP	977	201	210	206	5.2	0.837	128	102	147	133
45	AQ	994	248	223	254	3.8	0.977	134	134	160	179
46	AR	961	222	218	218	3.2	0.944	108	121	162	177

vE-40 is Charpy absorbed energy measured at -40°C with the repetition frequency n being three.
Weld heat-affected zone toughness is Charpy absorbed energy measured at -30°C with the repetition frequency n being three.
The conditions of weld heat-affected zone toughness are identical to the heat treatment conditions of weld reproducing heat cycle test.

Heating rate: 100°C/sec., retention time: 1 sec., cooling temperature range: 500°C to 800°C, cooling rate: 15°C/sec.

Condition 1: both first and second heating temperatures are 1,400°C.
Condition 2: first heating temperature is 1,400°C and second is 900°C.
Condition 3: both first and second heating temperatures are 1,400°C, and then heated to 350°C and retained for 5 minutes.
Condition 4: first heating temperature is 1,400°C and second is 900°C, and then heated to 350°C and retained for 5 minutes.

Example 5

The steel plates containing the chemical components of steels AA to AE shown in Table 7 were produced in the same manner as Example 4, then formed into pipes in a UO process, and subjected to submerged arc welding at a heat input of 2.0 to 3.0 kJ/mm on each of the inner surfaces and at a heat input of 2.0 to 3.0 kJ/mm on each of the outer surfaces. Subsequently, some of the steel pipes were heated to 350°C at the seam welds by induction heating and then held for five minutes, and thereafter cooled to the room temperature and subjected to pipe expansion, while some of the steel pipes were subjected to pipe expansion without heating the seam welds.

For investigating the mechanical properties of the base steels of those steel pipes, in the same manner as in Example 4, an API full thickness tensile test and a Charpy impact test were carried out, the Charpy impact test being carried out at -40°C using test pieces having the length in the C direction. The Charpy absorbed energy was obtained by measuring it with the repetition frequency n being three and averaging the three measured values. Further, weld heat-affected zone toughness was obtained by carrying out another Charpy impact test at -30°C with the repetition frequency n being three using test pieces each having a notch at an intersection or a portion 1 mm apart from an intersection and then averaging the resulting values.

The results are shown in Table 9. In Table 9, "As welded" in the column "Weld heat-affected zone toughness" represents the weld heat-affected zone toughness of a steel pipe subjected to pipe expansion without the heating of a seam weld and "Heat treatment" represents the weld heat-affected zone toughness of a steel pipe subjected to pipe expansion after a seam weld is heated by induction heating. In any of steels AA to AE, the tensile strength of the base steel is not lower than 900 MPa and, with respect to the toughness of the base steel,

the Charpy absorbed energy at -40°C is not lower than 200 J, and with respect to the toughness at the weld heat-affected zone, the Charpy absorbed energy at -30°C is not lower than 100 J. Therefore, high-strength steel pipes excellent in the low temperature toughness of the base steel and weld heat-affected zone toughness are obtained.

Table 9: Test conditions and evaluation result

Performance No.	Steel	Mechanical properties of steel pipe			Prior austenite	TS/ (3720[C] + 869)	Weld heat-affected zone toughness			
							As welded		Heat treatment	
		YS	TS	vE-40			Notch position	Notch position	Notch position 1,	Notch position 2,
		MPa	MPa	J	μm		J	J	J	J
47	AA	867	963	278	4.5					
48	AB	904	972	228	5.1	0.948	178	165	205	184
49	AC	940	1001	282	4.2	0.897	180	150	181	178
50	AD	963	1036	207	6.1	0.963	162	132	175	169
51	AE	988	1040	217	4.6	0.93	145	115	169	168
						0.967	148	118	165	169

Notch position 1 means a mating portion and notch position 2 means a portion 1 mm away from a mating portion.

CLAIMS

1. A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness, characterized by containing, in mass,

C: 0.02 to 0.10%,

Si: not more than 0.6%,

Mn: 1.5 to 2.5%,

P: not more than 0.015%,

S: not more than 0.003%,

Ni: 0.01 to 2.0%,

Mo: 0.2 to 0.6%,

Nb: less than 0.010%,

Ti: not more than 0.030%,

Al: not more than 0.070%, and

N: not more than 0.0060%,

with the balance consisting of Fe and unavoidable impurities; the P value of the steel defined by the following expression being in the range from 1.9 to 3.5; and the microstructure of the steel being mainly composed of martensite and bainite:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5.$$

2. A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness, characterized by containing, in mass,

C: 0.02 to 0.10%,

Si: not more than 0.6%,

Mn: 1.5 to 2.5%,

P: not more than 0.015%,

S: not more than 0.003%,

Ni: 0.01 to 2.0%,

Mo: 0.1 to 0.6%,

Nb: less than 0.010%,

Ti: not more than 0.030%,

B: 0.0003 to 0.0030%,

Al: not more than 0.070%, and

N: not more than 0.0060%, so as to satisfy the

expression $Ti - 3.4N \geqq 0$,
with the balance consisting of Fe and unavoidable impurities; the P value of the steel defined by the following expression being in the range from 2.5 to 4.0; and the microstructure of the steel being composed of martensite and bainite:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo.$$

3. A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness according to claim 1 or 2, characterized by further containing, in mass, one or more of

V: 0.001 to 0.10%,
Cu: 0.01 to 1.0%,
Cr: 0.01 to 1.0%,
Ca: 0.0001 to 0.01%,
REM: 0.0001 to 0.02%, and
Mg: 0.0001 to 0.006%.

4. A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness according to any one of claims 1 to 3, characterized by the average diameter of the prior austenite grains in the steel being not larger than 10 μm.

5. A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness, characterized by: containing, in mass,

C: 0.02 to less than 0.05%,
Si: not more than 0.6%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.001%,
Ni: 0.01 to 2.0%,
Mo: 0.1 to 0.6%,
Nb: less than 0.010%,
Ti: not more than 0.030%,

B: 0.0003 to 0.0030%,

Al: not more than 0.070%, and

N: not more than 0.0060%, so as to satisfy the expression Ti - 3.4N ≧ 0, and further one or more of

V: 0.001 to 0.10%,

Cu: 0.01 to 1.0%, and

Cr: 0.01 to 1.0%,

with the balance consisting of Fe and unavoidable impurities; the P value of the steel defined by the following expression being in the range from 2.5 to 4.0; the microstructure of the steel being composed of martensite and bainite; and the average diameter of the prior austenite grains in the steel being not larger than 10 μm:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo.$$

6. A high-strength steel excellent in low temperature toughness and weld heat-affected zone toughness, characterized by: containing, in mass,

C: 0.02 to less than 0.05%,

Si: not more than 0.6%,

Mn: 1.5 to 2.5%,

P: not more than 0.015%,

S: not more than 0.003%,

Ni: 0.01 to 2.0%,

Mo: 0.1 to 0.6%,

Nb: less than 0.010%,

Ti: not more than 0.030%,

B: 0.0003 to 0.0030%,

Al: not more than 0.070%, and

N: not more than 0.0060%, so as to satisfy the expression Ti - 3.4N ≧ 0, and further one or more of

V: 0.001 to 0.10%,

Cu: 0.01 to 1.0%,

Cr: 0.01 to 1.0%, and

Ca: 0.0001 to 0.01%,

with the balance consisting of Fe and unavoidable impurities; the P value of the steel defined by the following expression being in the range from 2.5 to 4.0; the microstructure of the steel being composed of martensite and bainite; and the average diameter of the prior austenite grains in the steel being not larger than 10 μm:

$$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo.$$

7. A method for producing a high-strength steel sheet excellent in low temperature toughness and weld heat-affected zone toughness, the method being the one for producing a steel plate from a casting containing components according to any one of claims 1 to 3, 5 and 6, characterized by: reheating the casting to a temperature of not lower than the Ac_3 point; hot rolling it; and thereafter cooling the resulting steel sheet at a cooling rate of not lower than 1°C/sec. to a temperature of not higher than 550°C.

8. A method for producing a high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to claim 7, characterized by: cold-forming a cooled steel plate into a pipe; and thereafter applying seam welding to the abutted portion thereof.

9. A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by, in the pipe having a seam-welded portion: the base steel containing, in mass,

C: 0.02 to 0.1%,
Si: not more than 0.8%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.003%,
Ni: 0.01 to 2%,
Mo: 0.2 to 0.8%,
Nb: less than 0.010%,

Ti: not more than 0.03%,

Al: not more than 0.1%, and

N: not more than 0.008%,

with the balance consisting of Fe and unavoidable impurities; the P value defined by the following expression being in the range from 1.9 to 4.0; and the microstructure being mainly composed of martensite and bainite:

$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + Mo - 0.5$.

10. A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by, in the pipe having a seam-welded portion, the base steel containing, in mass,

C: 0.02 to 0.10%,

Si: not more than 0.8%,

Mn: 1.5 to 2.5%,

P: not more than 0.015%,

S: not more than 0.003%,

Ni: 0.01 to 2%,

Mo: 0.1 to 0.8%,

Nb: less than 0.010%,

Ti: not more than 0.030%,

B: 0.0003 to 0.003%,

Al: not more than 0.1%, and

N: not more than 0.008%, so as to satisfy the expression $Ti - 3.4N \geqq 0$,

with the balance consisting of Fe and unavoidable impurities; the P value defined by the following expression being in the range from 2.5 to 4.0; and the microstructure being mainly composed of martensite and bainite:

$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo$.

11. A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to claim 9 or 10, characterized by

further containing, in mass, one or more of

V: 0.001 to 0.3%,

Cu: 0.01 to 1%,

Cr: 0.01 to 1%,

Ca: 0.0001 to 0.01%,

REM: 0.0001 to 0.02%, and

Mg: 0.0001 to 0.006%.

12. A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to any one of claims 9 to 11, characterized by the average diameter of the austenite grains in the steel pipe being not larger than 10 μm.

13. A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by, in the pipe having a seam-welded portion: the base steel containing, in mass,

C: 0.02 to less than 0.05%,

Si: not more than 0.8%,

Mn: 1.5 to 2.5%,

P: not more than 0.015%,

S: not more than 0.001%,

Ni: 0.01 to 2%,

Mo: 0.1 to 0.8%,

Nb: less than 0.010%,

Ti: not more than 0.030%,

B: 0.0003 to 0.003%,

Al: not more than 0.1%, and

N: not more than 0.008%, so as to satisfy the expression $Ti - 3.4N \geqq 0$, and further one or more of

V: 0.001 to 0.3%,

Cu: 0.01 to 1%, and

Cr: 0.01 to 1%,

with the balance consisting of Fe and unavoidable impurities; the P value defined by the following expression being in the range from 2.5 to 4.0; the microstructure being mainly composed of martensite and

bainite; and the average diameter of the austenite grains being not larger than 10 μm:

$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo$.

14. A high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by, in the pipe having a seam-welded portion, the base steel containing, in mass,

C: 0.02 to less than 0.05%,
Si: not more than 0.8%,
Mn: 1.5 to 2.5%,
P: not more than 0.015%,
S: not more than 0.003%,
Ni: 0.01 to 2%,
Mo: 0.1 to 0.8%,
Nb: less than 0.010%,
Ti: not more than 0.030%,
B: 0.0003 to 0.003%,
Al: not more than 0.1%, and
N: not more than 0.008%, so as to satisfy the expression $Ti - 3.4N \geqq 0$, and further one or more of
V: 0.001 to 0.3%,
Cu: 0.01 to 1%,
Cr: 0.01 to 1%, and
Ca: 0.0001 to 0.01%,

with the balance consisting of Fe and unavoidable impurities; the P value defined by the following expression being in the range from 2.5 to 4.0; the microstructure being mainly composed of martensite and bainite; and the average diameter of the austenite grains being not larger than 10 μm:

$P = 2.7C + 0.4Si + Mn + 0.8Cr + 0.45(Ni + Cu) + 2V + 1.5Mo$.

15. A method for producing a high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness, characterized by: reheating

the casting containing components according to any one of claims 9 to 14, to a temperature of not lower than the Ac_3 point; hot rolling it; thereafter cooling the resulting steel sheet at a cooling rate of not lower than 1°C/sec. to a temperature of not higher than 550°C; cold-forming the cooled steel plate into a pipe; then applying submerged arc welding to the abutted portion from the outer and inner sides thereof; and thereafter subjecting the steel pipe to pipe expansion.

16. A method for producing a high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to claim 15, characterized by heating the seam-welded portion of the steel pipe to 300°C to 500°C before pipe expansion.

17. A method for producing a high-strength steel pipe excellent in low temperature toughness and weld heat-affected zone toughness according to claim 15, characterized by heating the seam-welded portion of the steel pipe to 300°C to 500°C after pipe expansion.

HIGH-STRENGTH STEEL EXCELLENT IN LOW TEMPERATURE TOUGHNESS AND TOUGHNESS AT WELD HEAT-AFFECTED ZONE, METHOD FOR PRODUCING THE SAME, AND METHOD FOR PRODUCING HIGH-STRENGTH STEEL PIPE

ABSTRACT OF THE DISCLOSURE

The present invention provides an ultra-high-strength steel pipe excellent in weldability on site and a method for producing the steel pipe by improving the reliability of the low temperature toughness of a steel to which elements to enhance hardenability are added for furthering high-strengthening and also improving toughness at a weld heat affected zone subjected to double or more layer welding and, in the method, the steel is made to consist of a structure composed of bainite and/or martensite by containing prescribed amounts of C, Si, Mn, P, S, Ni, Mo, Nb, Ti, Al and N, and, as occasion demands, one or more of B, V, Cu, Cr, Ca, REM and Mg, and regulating C, Si, Mn, Cr, Ni, Cu, V and Mo, those being elements to enhance hardenability, by a specific relational expression. The diameter of prior austenite grains may be regulated in a prescribed range. The method includes the steps of heating a casting to a temperature not lower than the Ac_3 point, hot rolling it, and thereafter cooling the resulting hot-rolled steel plate at a prescribed cooling rate.

CA

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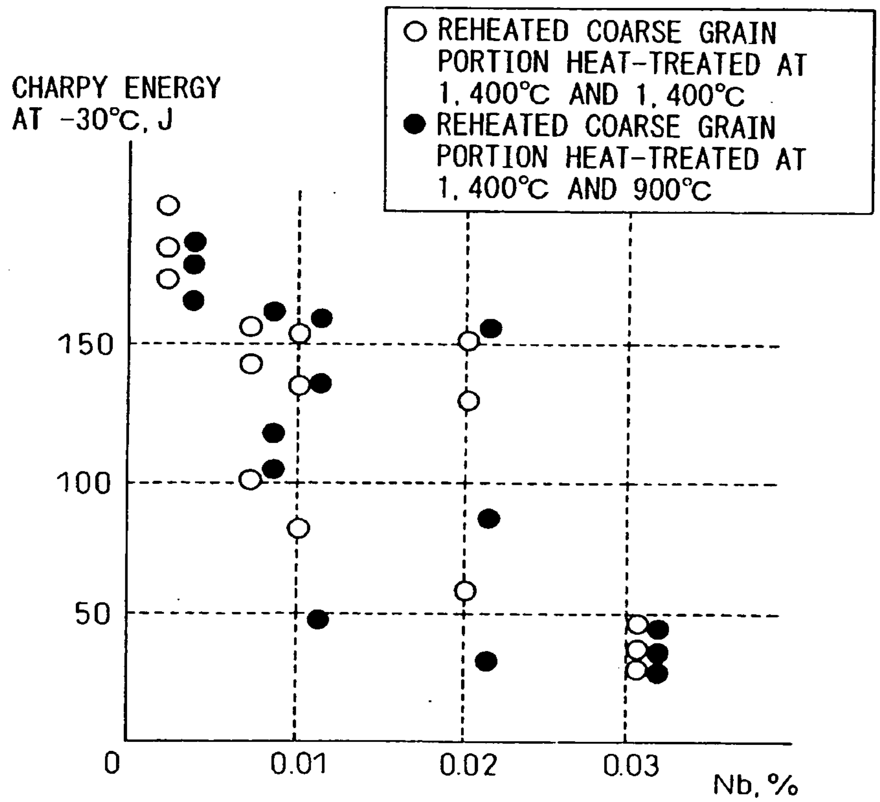
Fig. 1


CHARPY ENERGY
AT -30°C, J
○ REHEATED COARSE GRAIN PORTION HEAT-TREATED AT 1,400°C AND 1,400°C
● REHEATED COARSE GRAIN PORTION HEAT-TREATED AT 1,400°C AND 900°C
150
100
50
0
0.01
0.02
0.03
Nb, %